



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D3914-041
Job Sheet 206491



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/20

Job Tracking No:

Due Date: 3/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Basket - 1	1 pcs		3/10/20	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		K.S / MFL
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs		3/10/20	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS	
							QC 9 - 43	24	
							QC 9 - 50	J-89	
							QC 9 - 9		
120	QC 5	1		3/10/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	J-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



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Container No: S255052



Part: D3914-041

Job No: 206491

Serial No/Batch: S255052

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/12/20

Plex 1/31/20 11:19 AM Dart.lajeunesse.marie

						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	3/10/20	0.00	0.40		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	BEB 20-02-25
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
135 QC 3	1 pcs	3/10/20	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	M 20-2-25
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	3/10/20	0.00	0.80		Handfinish - 3 - 1 - B4B	M 20-2-27
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	3/10/20	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	

DAS
15
89

						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	FEB 25 2020 DAS
						QC 3 - 19	40
						QC 3 - 43	9-32
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
						Packaging 3 - 1 - B4B	20-2-25
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
160 Packaging 3-1 - Stock - B4B	1 pcs	3/10/20	0.00	0.00		Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	1 pcs	3/10/20	0.00 0.00	QC 21 - SA - 21	AS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M139023 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat**START 8:40 TEM 17320

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5246180
D3914-1 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5243936
D3914-7 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5242129
D4016-3 ✓	Hinge Half, Lid	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5221960
D4018-5 ✓	Rib	9 pcs (9 ea) ✓	100-Large Fab - Basket - 1	5241530
D4020-5 ✓	Mesh (350 Basket Long, Lid)	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5244793
D4021-3 ✓	Data Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5229416
D4035-043 ✓	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5246294

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	60	0
	D3914-1	2	10	0
	D3914-7	2	10	0
	D4016-3	3	306	0
	D4018-5	9	54	0
	D4020-5	1	5	0
	D4021-3	1	18	0
	D4035-043	2	5	0

Part Specifications

Specifications could not be found.

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QSI042)																	
Date: _____		Sequence #: _____		QTY Affected: _____																			
Description Work Order Deviation		Disposition																					
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		Pressure/Forced		Contamination		Power Loss/Surge	
		Operator																					
		Manufacturing Process																					
Equip/Tooling																							
Handling/Preservation																							
Material																							
Product Improvement																							
Process Improvement																							
Human Factors																							
Bending		Misaligned/off center		Folio/Program		Positioned Wrong																	
Crushing		BOM/Route		Grain Direction		Outside Tolerance																	
Cracks		Broken/Damage/Defect		Weld		Drawing																	
Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Finish																	
Marks/Chatter		Drill Holes		Out of Sequence		Part Lost/Missing																	
Mislabeled		Fit/Function		Off-set/Set-up		Misread																	
Other/Details: _____																							
		Completed By _____																					
		Lead hand / Supervisor _____																					
		QC / QA Coordinator _____																					